

Work Order ID 70972 - 2



Page 1

Monday, June 20, 2011 2:45:07 PM

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/20/2011 Start Qty: 50.00

Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 50.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 6/20/2011

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

11-6-22

GO

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-6-22

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 w/06/22

counts
x60

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Page 2

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Required Date: 6/23/2011 Req'd Qty: 50.00



Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

SB 11/06/29

(60)

140



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat
11/18/16 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

(48)

11-27-22 JB/EL

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

48

11.07.22

(48)

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Start Date: 6/20/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W 11 07 22 48

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

7:35

FINISH TIME:

OVEN TEMPERATURE:

8.05.

48 0 RF 11-7-25.

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

48 0 RF 11-7-25.

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Start Date: 6/20/2011 Start Qty: 50.00

Required Date: 6/23/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Packaging

Memo

0.00

0.00

48 d 24 11/25/11

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/25/11

11/25/11

Picklist Print

Monday, June 20, 2011 2:45:14 PM

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Work Order ID: 70972



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

30.2000

0.106

5.578947

6.5



IB11-6-22

304/316 Sheet.063

Location

Loc Qty

Loc Code

MAT020

30.2

117275

2.3

117653

27.9

117653

60

SHIP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

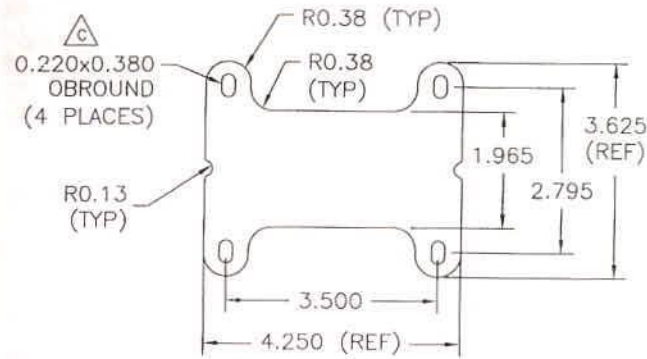
SUBJECT TO AMENDMENT

WITHOUT NOTICE

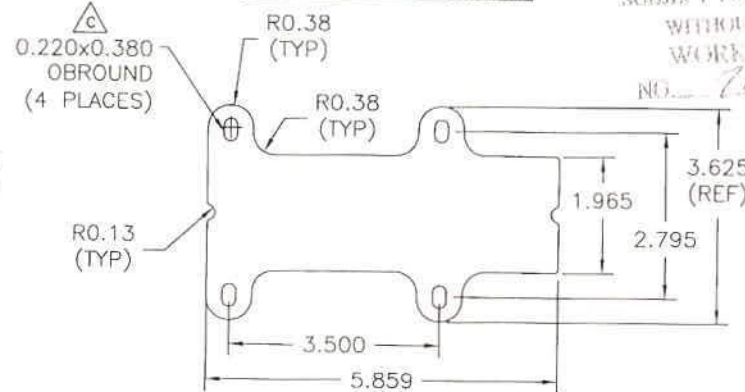
WORK ORDER

NO. 70872

D3537-1F FLAT PATTERN

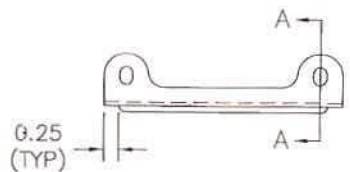


D3537-3F FLAT PATTERN



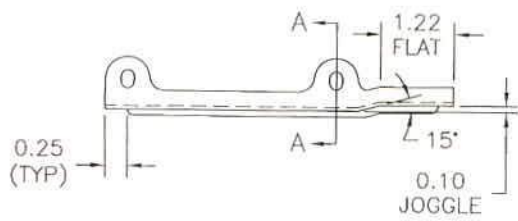
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



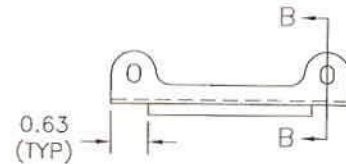
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)

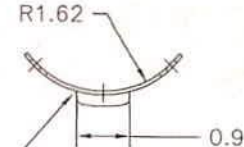


D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)

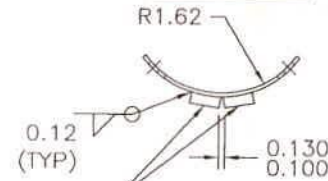


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

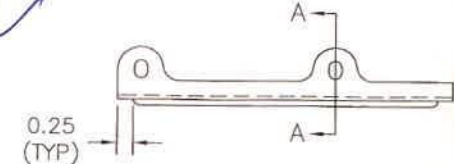
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DART AEROSPACE USA, INC.	PORT HADLOCK, MA	REV. C
DRAWING NO. D3537		SHEET 1 OF 1
		SCALE 1:2

RELEASED 07.05.08 AM

PER ECA 962

70972